

Date: Thursday, 02/04/2009 2:28:50 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 46886
 Estimate Number : 12712
 P.O. Number :
 This Issue : 02/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D35371
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3537 REV C
 Previous Run : 46650 Drawing Revision : C
 Material :
 Due Date : 17/04/2009 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : JUD 09.04.03
 Comment : Est Rev:A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0.1113 sf(s)/Unit Total : 4.4520 sf(s)
 M304S16GA .063" 304 SS SHEET
 Batch: 111323

ml 09.04.07 (40)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3537
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary

ml 09.04.07 (40)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09.04.07

(40)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/04/07 counter (40)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.
 2-Identify as D3537-1

09/04/09 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:28:50 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 46886

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat M111207
1-Weld as per Dwg D3537 using Jig DT 8210
2-Remove any weld that penetrated through Wearpad if necessary

EL 9-4-22 (X40)

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

counter
8 09/04/22 (X40)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
8 02/04/22 (X40)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109091

START TIME: 1:30
OVEN TEMPERATURE: 320°
FINISH TIME: 2:00

(40)

BR 09-04-23

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-23 (40)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP #17

UND FL

09/04/23 (X40)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24

Job Completion



U 09-04-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

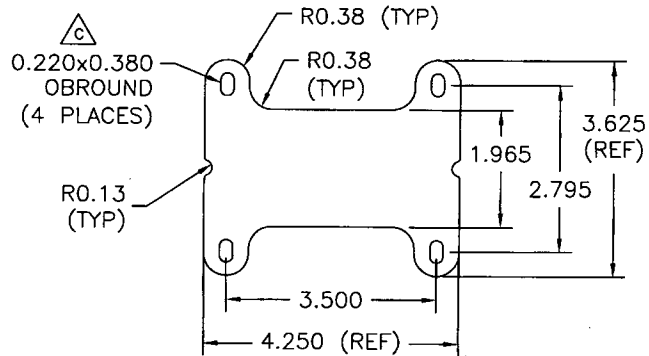
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

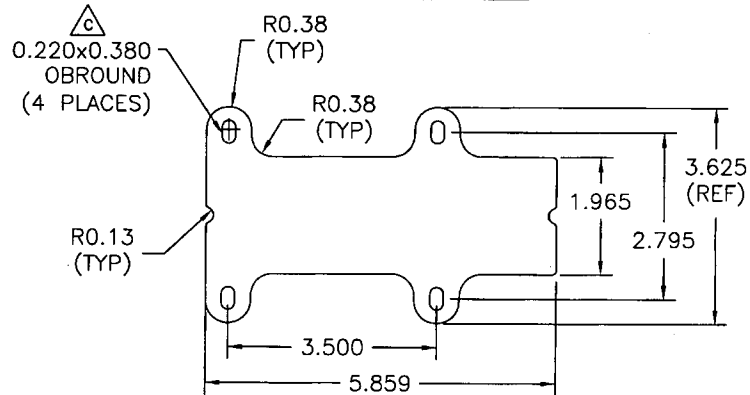
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

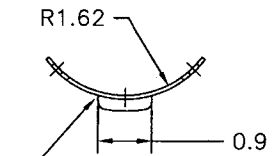
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

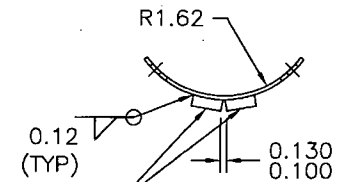


SECTION A-A



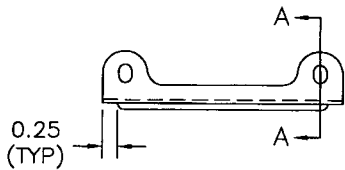
2. APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B

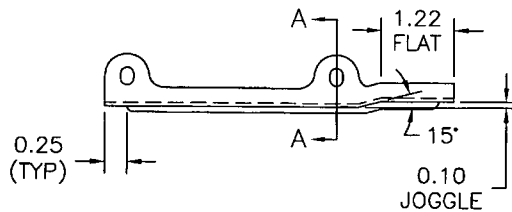


- D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

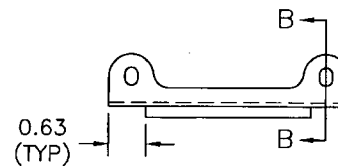
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



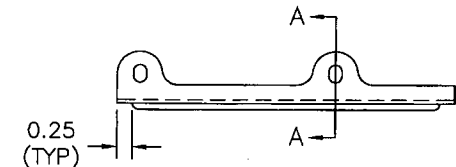
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)




D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
2) BREAK ALL SHARP CORNERS 0.063 MAX
3) WELD PER QSI 004
4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN	
B	07.03.20	ADD AMS 5513 AND AMS 5524	
A	06.11.06	NEW ISSUE	
DESIGN	CB	DRAWN BY	PH
CHECKED	#	APPROVED	#
DATE	07.04.13	 DART AEROSPACE USA, INC. PORT HADLOCK, MA	
		DRAWING NO.	REV. C
		D3537	SHEET 1 OF 1
		TITLE	SCALE
		WEARPAD	1:2

RELEASED
07-05-08 PM
PER ECU
BEND 952